

WHAT IS CLAIMED IS:

1. A cutting tool assembly comprising:  
a support block to be secured to a moving element of a mining machine,  
comprising:  
a protection sleeve fixed into said support block;  
5 a replaceable spray nozzle housing welded onto said support block;  
a block fluid passage located in said support block wherein said replaceable  
nozzle housing is in fluid communication with said block fluid passage.
2. The cutting tool assembly according to claim 1, wherein said block  
fluid passage has an upstream portion and downstream portion.
3. The cutting tool assembly according to claim 1, wherein the support  
block has a first outer surface and a second outer surface and the block passage  
communicates fluid between said first outer surface and said second outer surface.
4. The cutting tool assembly according to claim 3, wherein said  
replaceable nozzle housing is fixed to said first outer surface.
5. The cutting tool assembly according to claim 2, wherein said upstream  
portion and said downstream portion are substantially straight so as to permit a drill to  
be inserted into said first fluid passage for cleaning.
6. The cutting tool assembly according to claim 1, further comprising:  
a cutting tool,  
said cutting tool extends through said protective sleeve.
7. A block for a cutting tool assembly, said block comprising:  
a support block to be secured to a moving element of a mining machine; and  
a spray nozzle housing,  
wherein said spray nozzle housing is welded to said support block.

8. The cutting tool assembly according to claim 7, wherein the support block has a first outer surface and a second outer surface, wherein a block fluid passage communicates fluid between an inlet in a first outer surface and an outlet in a second outer surface.

9. The cutting tool assembly according to claim 8, wherein said block fluid passage has an upstream portion and downstream portion.

10. The cutting tool assembly according to claim 9, wherein said upstream portion and said downstream portion are substantially straight so as to permit a drill to be inserted into said block fluid passage for cleaning.

11. The cutting tool assembly according to claim 8, wherein said spray housing nozzle includes a fluid passage open end in communication with the support block fluid outlet.

12. The cutting tool assembly according claim 11 wherein said open end has a cross-sectional area at least twice as great as the cross-sectional area of the block outlet.

13. The cutting tool assembly according to claim 7 wherein said spray nozzle housing has a bottom surface that cooperates together with a first outer surface of the support block to form contact surfaces.

14. A method of making a cutting bit support block having a spray nozzle comprising the steps of:

providing a cutter bit support block with a block fluid passage having an outlet opening wherein the support block is either cast or cold-formed from a heat treatable weldable steel;

providing a spray nozzle housing with a fluid passage having an open end;  
connecting the spray nozzle housing to the support block.

15. The method of claim 14 wherein the support block has a block fluid passage with an inlet for connection to a water supply and a support block outlet at the opposite end of said block fluid passage; said spray nozzle housing having a recess chamber;

5 wherein said connecting includes aligning an open end of said recess chamber with said support block outlet.

16. The method of claim 14 wherein said connecting comprises welding said spray housing nozzle to said support block.

17. A generally cylindrical spray nozzle housing comprising:  
a generally circular forward face having an outlet; and  
a bottom surface,  
wherein said bottom surface has an elongated recess chamber.

18. The generally cylindrical spray nozzle housing according to claim 17 wherein said bottom surface is generally flat.

19. The generally cylindrical spray nozzle housing according to claim 17, wherein said generally cylindrical spray nozzle has a central longitudinal axis, said generally flat bottom surface is oriented at an angle between from  $2^{\circ}$  to about  $20^{\circ}$ .